Work Order ID 689 Wednesday, April 27, 2011 10										Pa	age 1
Item ID: D3195-041		Α	Accept					Setup	Start		
Revision ID:  Item Name: Bracket Assemi	hlv					· · - · · · · ·					
Start Date: 4/27/2011 Required Date: 4/29/2011 Reference:	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item :	D:				· 1	1883361 BIBIB IIB IIB	11111
Approvals: Process Plan	n:	Date:////4-2-7	Tooling: SPC (Y/N):		ate:				٠		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		ject Insp. mber Stam	
Draw Nbr Revi	sion Nbr										
D3195 Rev	A										
100 Bandsaw Jeaspa Bandsaw	BAND SAW Memo Cut blanks:	: (0.75" x 2.00") x 3.60" long	0.00	11/65/05		Ä	8	·			
110 HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICA  Memo  Machine D	L MACHINING #1 3195-1 as per Folio FA334 an	0.00 0.00 ad Dwg D3195□Ident	ify as D3195-	11/05/10		<u>X</u>		,		

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

W/O:			١ ١	WORK ORDER CHANG	iES		<del></del>	
DATE	STEP	PRO	CEDURE C	HANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault C	ategory:	NCR: Yes	No <b>DQA:</b>	Date: _	
	R	esolution:	Dispos	tion:	QA: N/C CI	osed:	Date: _	
NCR:		V	VORK OF	DER NON-CONFORM	ANCE (NCF	R)		
DATE	STEP	Description of NC			tion B	Verification		Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector
					e			
•								

NOTE: Date & initial all entries

### Work Order ID 68998

Wednesday, April 27, 2011 10:42:16 AM



Page 2

Item ID:

D3195-041

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Bracket Assembly

Start Date:

Required Date: 4/29/2011

4/27/2011

Start Otv: 4.00

Reg'd Otv: 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

OC:

Date:

SPC (Y/N):

Tool ID

Date: Tool # Plan

Code

Reject Qty

Reject Insp. Number

Stamp

Work Center ID

130

Sequence ID/

Quality Control

Operation Description

OC8- Inspect parts - second check

Memo

Run Hours

0.00

0.00

Set Up/

129 11.5.10

Accept

Qty

Stop

140

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

0.00

Memo

0.00

4x & m/ 1/05/10

150



Powder Coating

Memo START TIME:

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

□OVEN TEMPERATURE:

320 OLDFINISH TIME:

4x & m/11/05/10

W/O:			1 ,	WORK ORDER CHANG	ES				1,111
DATE	STEP	PROCE	EDURE C	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault C	ategory:	_ NCR: Yes	No DQA	:	Date:	
	R	esolution:	Dispos	ition:	_ QA: N/C CI	osed:		Date: _	
NCR:		WC	ORKO	RDER NON-CONFORMA	NCE (NCF	1)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign 8 Date	Verifica Sectio		Approval Chief Eng	Approval QC Inspector
			Official	Office Ling	Dute				

### Work Order ID 68998

Wednesday, April 27, 2011 10:42:16 AM



Page 3

Item ID:

D3195-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Bracket Assembly

**Start Date:** 

Required Date: 4/29/2011

4/27/2011

Start Qty: 4.00

**Req'd Qty:** 4.00

Date:\_\_\_\_

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date: \_\_\_\_

Run Start

Stop



Sequence ID/ **Work Center ID** 

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan

Accept Qty Code

Reject Qty

Reject Number Insp. Stamp

170

Small Fab Small Fab

Small Fab

Memo

0.00

0.00

1-Lightly Sand bonding surface □2-Bond D3195-5 into D3195-1 as per Dwg

QC5- Inspect part completeness to step on W/O

D3195 A/RContact Cement M/1/095

180

Quality Control

Memo

0.00

Jules 111

W/O:			1	WO	RK ORDER CHANG	iES					
DATE	STEP	PRO	CEDURE	CHAI	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disp	sitior	n:	QA:	N/C CIC	sed:		Date: _	
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DATE	STEP	Description of NC	Initia		Corrective Action Sect Action Description	tion B	Sign &		cation	Approval	Approval
		Section A	Chief Er		Chief Eng		Date	Sect	ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

### Work Order ID 68998

Wednesday, April 27, 2011 10:42:16 AM



Page 4

Item ID:

D3195-041

Accept

Setup Start

Stop

Start



**Revision ID:** 

Item Name: **Bracket Assembly** 

**Start Date:** 

4/27/2011

Start Qty: 4.00

Required Date: 4/29/2011

**Req'd Qty:** 4.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

QC:

Process Plan:

Operation

Description

Identify as per dwg & Stock Location: 246A

Date:

Date:

**Tooling:** SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Stop

Run

Sequence ID/

Work Center ID

190

Packaging

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Insp. Stamp Number

Packaging

200

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

	-										
W/O:				W	ORK ORDER CHANGI	ES					
DATE	STEP	PRO	CEDURE	СН	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NOTE: Date & initial all entries

### **Picklist Print**

Wednesday, April 27, 2011 10:42:22 AM

Work Order ID: 68998

Parent Item:

D3195-041

Parent Item Name:

Bracket Assembly



Start Date: 4/27/2011

Required Date: 4/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-5		Manufactured	No			100	Each	0.0000 UUV		4			/
Pad M6061T6B0.750X02.00	((III ( <b>48</b> ))	Purchased	No			170	f f	29.0300	0.3	1.263158	1 <i>7 7 0</i> 3	5//	

6061-T6 Bar .750 x 2.00

Location Loc Qty Loc Code MAT003 29.03 8.3 100742 111448 20.73

JL 11/05/05

Page 1

W/O:			-	WORK ORDER	CHANGES				
DATE	STEP	PROC	EDURE	CHANGE	OHAITGES	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		· .							
Part No	:	PAR #:	_ Fault	Category:	NCF	R: Yes N	o <b>DQA</b> :	Date:	
	Re	esolution:	Disp	osition:	QA:	N/C Clos	sed:	Date: _	
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DATE	STEP	Description of NC		Corrective Acti			Verification	Approval	Approval
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48998
Description: Bracket	Part Number:	D3195-1
Inspection Dwg: D3195 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

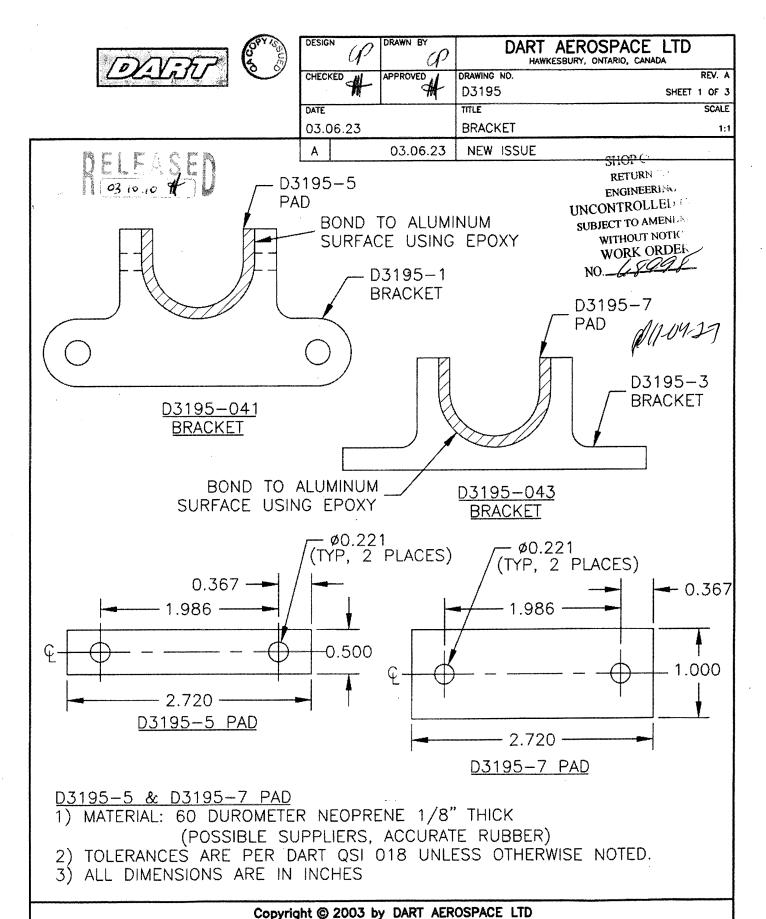
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.242	+/-0.010	243			to.	
1.084	+/-0.010	1085			H-G	
R0.200	+/-0.010	200	/			
R0.377	+/-0.010	377				
Ø0.277	+0.005/-0.000	-279			*	
2.677	+/-0.005	2677				
3.432	+/-0.010	3,430	1		•	
0.754	+/-0.010	754	and 1		`	
1.387	+/-0.010	1.387	2000		~	
0.500	+/-0.010	496			~	
0.250	+/-0.005	.248	1			
1.754	+/-0.010	1.754	1			
Ø0.191	+0.005/-0.000	.192			ىد	
	·					10%
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Measured by:	Sh	Audited by:	<b>176</b>	Prototype Approval:	N/A
Date:	1/05/10	Date:	11.5.10	Date:	N/A
<u> </u>	110				

Rev	Date	Change		Revised by	Approved
A	04.04.20	New Issue	(P/O D412-702-011/-13)	KJ/RF	<u></u> -∤4

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W/O:			WO	RK ORDER CH	ANGES					
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NOTE: Date & initial all entries



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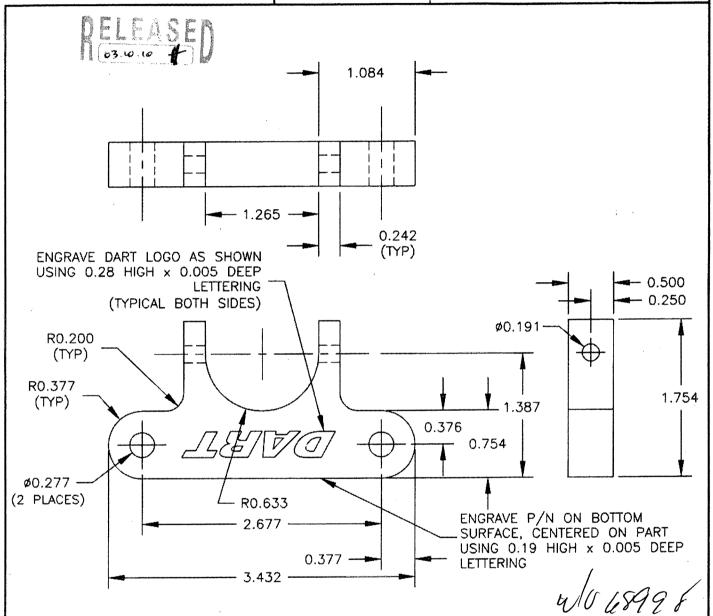
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DATE		<del></del>	TITLE		SCALE
03.06	.23		BRACKET		1:1



#### D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS ÓTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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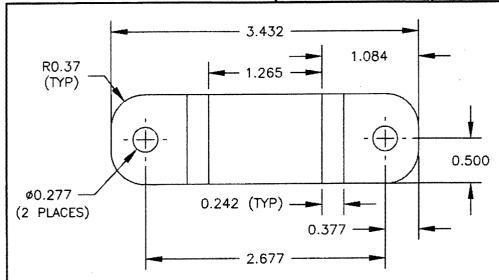
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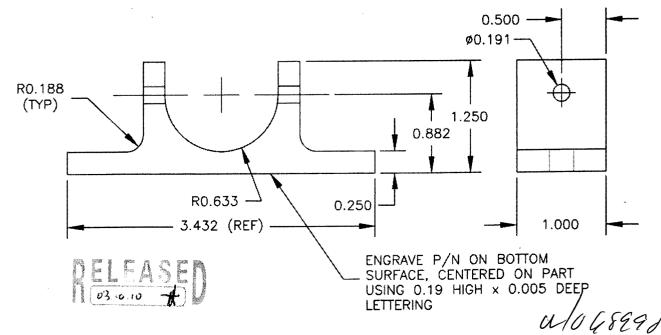
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DATE		TITLE	SCALE
03.06.23		BRACKET	1:1





#### D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:			W	ORK ORDER C	HANGES					
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